

5/20


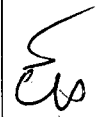
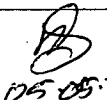

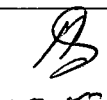
DART AEROSPACE LTD	Work Order:	23021
Description: Guide	Part Number:	D3333-5
B		
Dwg: D3333 Rev. A PAGE 3	Qty:	40 41 40
05.04.12		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.13	40
2	MV	Cut blanks: 1.500" x 1.000" thick x 7.500" long Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B1.500x01.000) Identify for D3333-5 Batch: M17353	EN	05/05/13	
3	MV	Machine as per Folio FA484 and Dwg D3333 Identify as D3333-5	SD	05.05.07	40 PTD
4	QC2	Inspect parts as they come off the CNC machine	SD	05.05.07	40
5	MV	Tap holes as per Dwg D3333	SD	05.05.12	40
6	QC8	Second check	EE	05.05.12	40
7	MV	Deburr	SD	05.05.07	40
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Ensure to mask threaded holes	ML	05 05 19	40
9	QC3	Inspect Powder Coat	ml	05/05/30	40
10	ST	Identify and Stock	ml	05/05/30	40
11	AC	Cost / part: 12.39	595	05.05.31	40
12	DC	Close W/O 12.74 Inspect Level 21	KJ	05.06.08	40

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05 01 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23021		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/06	D3	one part scrap. PART WAS NOT STRAIGHT IN USE.	 PART 12	destroy & replace	 05/05/06	 05.05.31	 PART 17	 05.05.31

Part No: D3333-5

PAR #: _____

Fault Category: Prod / Machine ^{PARTS} NCR: Yes NoDQA: 

Date: 05/06/08

NOTE: Date & initial all entries

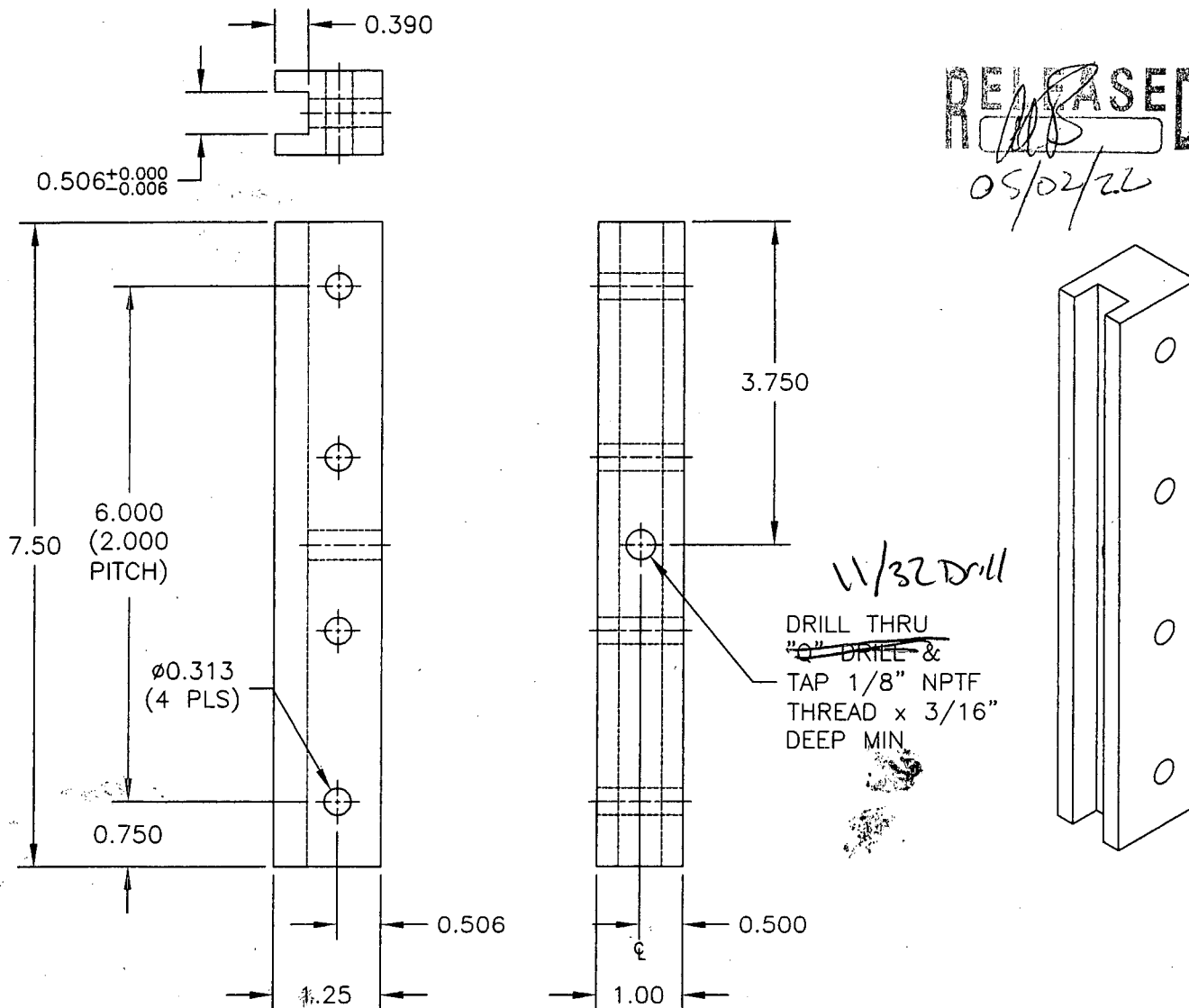
QA: N/C Closed: 

Date: 05.06.08



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2

RELEASED
[Signature]
05/02/22



D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3.5.10 WITHOUT NOTICE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

WORK ORDER
NO. 23021

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023021
Project Name : D3333-5
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3333-5
Description : Rail
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

